

Work Order ID 57838

Friday, April 16, 2010 12:57:33 PM



Page 1

Item ID: D3911-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Basket Plate-Eyebolt Receiver

Start Date: 4/19/2010 Start Qty: 24.00



Cust Item ID:

Required Date: 4/23/2010 Req'd Qty: 24.00



Customer:

Reference:

Approvals:

Process Plan:

mk

Date:

10-4-16

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3911

C

100

0.00



Waterjet

FLOW CNC Waterjet

304.125

Memo

0.00

Cut as per Dwg and File

DWG REV: *E*PROG REV: *E*

DEBURR

*Debur mk 10/04/14**(27x)**(27)*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

B 10-4-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

Sub 6/20



QC

Memo

0.00

(126)

P10 →

Quality Control

130

Identify as per dwg & Stock Location: 95

0.00



Packaging

Memo

0.00

10-4-21

26 Sp

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

10/04/22

Quality Control

MF

10-4-22

W/O: 57838		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/04/20	#170	Took Qty +1 For QC inspection template	S	10/04/20	x1		S 10/04/20

Part No: D3911-7 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 57838



Parent Item: D3911-7



Parent Item Name: Basket Plate-Eyebolt Receiver

Start Date: 4/19/2010

Required Date: 4/23/2010

Comments: IPP REV:A NEW ISSUE JLM 10-02-09 VERIFIED BY:EC IPP
REV:B AS PER REV B 10-03-23 JLM VERIFIED BY:DD

Start Qty: 24.00

Required Qty: 24.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			100	sf	20.2000	0.8059	1.1		



304/316 0.125 Sheet



13104-19

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
MAT19	20.2	
112663	20.2	

27

112663

Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 57838
Description: BASKET PLATE-EYE BOLT RECEIVER		Part Number: D3911-7
Inspection Dwg: D3911-7, Rev: C		Page 1 of 1

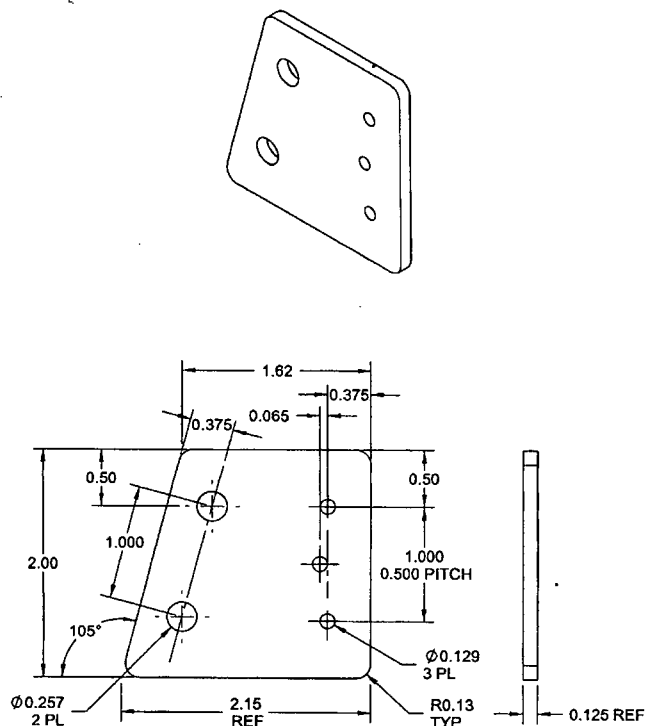
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .257	+ .006 - .001	.260	X			
Ø .129	+ .005 - .001	.132	X			
.375	± .010	.375	X			
1.000	± .010	1.001	X			
.454	± .010	.457	X			
1.99	± .030	1.99	X			
.83	± .030	.833	X			
1.75	± .030	1.747	X			
1.000	± .010	1.002	X			
.450	± .010	.448	X			
.508	± .010	.497	X			
.150	± .010	.150	X			
.250	± .010	.248	X			
.500	± .010	.501	X			
1.100	± .010	1.100	X			
1.250	± .010	1.253	X			
1.763	± .010	1.764	X			
2.27	± .030	2.260	X			
.125	± .010	.118	X			

Measured by: HB	Audited by: S	Prototype Approval:
Date: 10-4-19	Date: 10/04/20	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

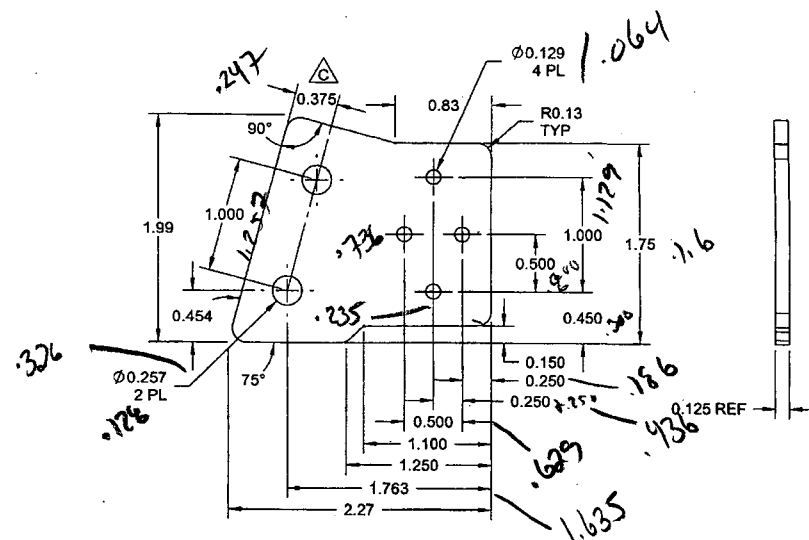


D3911-5 BASKET STUD PLATE

NOTES:





- 1) MATERIAL -5 & -7: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME 5A240
PER DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
- 7) WEIGHT -5: 0.13 lbs
-7: 0.13 lbs

#57838



D3911-7 BASKET PLATE-EYEBOLT RECEIVER

RELEASED
2010-04-14

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3911	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		AFT HARDPOINT, BASKET	
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
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